Work Orde April-22-13 1:4		00508		*100)508 *						Page 1
Item ID: Revision ID: Item Name:	D3910-3 Crosstube Lu	ug	7	Accept	*N900	040	100	* s	etup Star Stoj	i V	S1* S2*
Start Date: Required Date: Reference:	4/18/13 5/03/13	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item I Customer:	D:					
Approvals:	Process P	lan: ML丁	Date: 13-04-25	Tooling:	Da	ate:		ŀ	Run Star Sto _l	171	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:			510	* *N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Re	evision Nbr						7.20			
D3910	В										
100				0.00							
100 Bandsaw Jeaspa Bandsaw		Memo Cut to 1.450	"Long males,	0.00					:		
110				0.00						,	
110 HAAS I HAAS CNC vertica	und I machine #1	FOLIO REV DWG REV: DEBURR			D//	D'. 197) () ()	<u>c</u>	<u> L1316</u>	04/29	40_
		ma	enine as	P10 to m	etec 770.	7.19. Reu.	122 B				

											DQA	v: Da	ite:	-
NCR: Y	es /	No !				WORK ORDER NON-	COI	NFORM	AANCE / UP	DATE			•	•
											QA Close	d: Da	ite:	
Work Orde	r i .	:				DISPOSITION				AGAINST D	EPARTMEN	T/PROCESS		
WOIR OIGC	··· —					Rework	7		Skid-tube	Crosstube	7	Water Jet		Engineering
Part N	lo					Scrap]	ľ	Machining	Small Fab	-	od. Eng. Coor.	\vdash	Quality
						Use-as-is	. ↓		noforming	Finishing	Rec/St	ore/Packaging	-	Other
NCR N	lo	į				Work Order Update	_	!	Large Fab	Composite		Supplier	Ш	
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &			
Cause	Da	ate :	Step	Qty	(or Non-conformance	Ct	nief Eng	Desc	ription	Date	Verificatio	n	QC Inspector
Doc/Data		t					İ	:						
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Operator		1									1			
Material												•		
Setup		'		•										
Other									•					
Process		1												
Supplier														
Training														
Unapproved		1.1					<u>L</u>							
							AUI	LT CATE	GORY					
Landir	ng Gear	I				General		-		_	_		, ,	
	Ben	ding			L.	Bend	L	Grain		L	Ovalized		\vdash	Pressure/Forced
`	Cen	tre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re	L	Over/Und	er tolerance	-	Temperature/Cure
	Crac	ks				Broken/Damaged	L	Inspecti	on Incomplete		Part Incorr	ect		Weld
	Crus	hed/C	rimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/i	Missing		Wrong Stock Pulled
	Cuff	s				Contamination		Mainte	nance		Part Move	d		
	Hea	t Treat	t			Countersink		Mislabe	led		Positioned	Wrong	_	
·	insp	ection	Strip in	Tube		Cut Too Short		Misread				s/Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Torque Waves in Extrusion

Turning Sequence

Wave/Twist in Tube

Drill Holes

Drawing

Finish Folio

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Work Orde		100508		*100	508*							Page 2	2
Revision ID:	D3910-3 Crosstube I	lua		Accept	*N900	040	100)* 5	Setup	Start Stop		S1* S2*	
	4/18/13	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item I Customer:	D:					I VI .		
Approvals:		Plan:	Date:	Tooling: SPC (Y/N):		ate:		I		Start Stop		R1* R2*	
Sequence ID/ Work Center II 20 *120* QC Quality Control		Operation Description OC2-Inspect parts off me Memo Alcal + The	•	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	
130 *130* QC Quality Control	a	QCk-Inspect parts - seco	nd check	0.00 AS 0.00 27 0.00 S 9			ος	40			, '	-,	
140 *14 HandFinish		Chemical Conversion Co	at per QS1005 4.1	0.00		. •		40	H	B_&	3-5~	9	

Memo

Hand Finishing

	!							DQA:	Date:	
NCR: Yes	s / No			WORK ORDER NON-	CONFO	RMANCE / UI	PDATE	QA Closed:	Date:	
Work Order:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No				 Rework Scrap Use-as-is Work Order Update	The	Skid-tube Machining ermoforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause	Date	Step	Qty	ption of work order update or Non-conformance	Initial Chief E	i	ction cription	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved										
				F	AULT CA	TEGORY				
Landing	Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection Ripples in Torque W Turning S	Crimped It In Strip in Isend Vaves in I	Tube Extrusion	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish	Inspo Instr Mai Misl Misr Offso	lware ection Incomplete ructions Incomplete ntenance abeled read	/Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct sissing .	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Wave/Tw	ist in Tul	be	Folio		Outside Dimensions				

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Work Order April-22-13 1:42:4		0508		*100	1508*			Page 3
Revision ID:	3910-3			Accept	*N90004	0100* - s	Setup Start Stop	*NS1* *NS2*
Start Date: 4/ Required Date: 5/ Reference:	/18/13 /03/13	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item ID: Customer:			
		n:	Date:	Tooling: SPC (Y/N):	Date:		Run Start Stop	*NR1* *NR2*
Sequence ID/ Work Center ID 150 *150* Powdercoat Powder Coating	M	Operation Description White Gloss(Ref:4.3.5.1) Memo	per QS1005 4.3-Alum 10: 10 . 37) ? 10: 40 .	Set Up/ Run Hours 0.00	Tool ID Tool	l# Plan Accept Code Qty	Qty	Reject Insp. Number Stamp
*160 *160* QC Quality Control		QC3- Inspect Part Finish Memo		0.00		40x y	/ M/	13/05/13
170 *170* Packaging Packaging	> *	ldentify as per dwg & Sto	Sty 6 9	0.00			93/	5/3 (29

NCR: Ye	es / No	1			WORK ORDER NON-O	CON	FORN	//ANCE / UP	PDATE			•
		: 							-	QA Closed:	Date:	:
Work Order		1			DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Oraci	•	1			Rework	7 I		Skid-tube	Crosstube		Water Jet	Engineering
Part No	o .	1			Scrap	11		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
		1			Use-as-is	1		noforming	Finishing	1	re/Packaging	Other
NCR No	o	: !			Work Order Update	1		Large Fab	Composite		Supplier	
Root	•			Descri	tion of work order update	In	itial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance		ef Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data		<u> </u>					_		· · · · · · · · · · · · · · · · · · ·			
Equip/Tooling		<u> </u>										
Operator												
Material						1						
Setup												
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Process	i					İ						
Supplier	1		ļ									
Training	·]		•				
Unapproved	j							·				
					<u> </u>	AULT	CATE	GORY				
Landing	g Gear				General	_				•	_	_
	Bending				Bend	Ц°	Grain		ļ	Ovalized	<u> </u>	Pressure/Forced
L	Centre No	ot Conce	ntric to (o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
L	Cracks				Broken/Damaged	Ľ	nspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs	<u></u>	nstruct	ions Incomplete	/Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat Trea	at			Countersink		Mislabe	led		Positioned V	Vrong	-
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	l		Power Loss/	Surge	Other
	Ripplesin	Bend			Drill Holes		Offset					
	Torque N	aves in l	Extrusio	າ [Drawing		Out of C	Calibration				
	Turning S	equence			Finish		Out of S	Sequence				
	Wave/Tw	ist in Tul	ре		Folio	\Box	Outside	Dimensions				

DQA: _____ Date: _____

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Work Order ID 100508 April-22-13 1:42:43 PM		*100)508 *						Page 4			
Item ID: Revision ID: Item Name:	D3910-3 Crosstube Li	цg		Accept	*N900	040	100)*	Setup	Start Stop	*NS1* *NS2*	
Start Date: Required Date Reference:	4/18/13 e: 5/03/13	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item II Customer:	D:	·				, te	
Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):	Da	te:			Run	Start Stop	*NR1* *NR2*	
Sequence ID/ Work Center 180 *120* QC QC	ID	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept	Qty [:	3/5/	Reject Insp. Number Stamp	,
Quality Control										ML	J 13-05-1	-

NCR:	res	/ No	i			WORK ORDER NON-C	.Or	NFORI	MANCE / UP	DATE	c	QA Closed:	D	ate:	·
·			- 		<u>.</u>	DISPOSITION				AGAINST [
Work Orde	er: _		!			DISPOSITION	.			_	JEF /				
Part I	-					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Je d. Eng. Coor re/Packaging Supplie		Engineering Quality Other
NCNI	۱U		<u> </u>	· V. · ·		Work Order Opdate	1		raige rab	Composite			Supplie	<u>'</u>	
Root			!-		Descri	ption of work order update		nitial	Ac	tion	T	Sign &			
Cause	ŀ	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	on	QC Inspector
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Equip/Tooling							١								
Operator															
Material															
Setup				ļ											į
Other	Ш	:													
Process	Ш										İ				
Supplier	Ш	i i													
Training	Ш	i													
Unapproved											\perp				
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Landi		1			_	General	_	1		۲	_				
	-	Bending			_ _	Bend		Grain		-	_	Ovalized		\vdash	Pressure/Forced
	$\boldsymbol{\vdash}$	Centre No	t Conce	ntric to	o/s	BOM/Route	_	Hardwa	-	-	_	Over/Under		\vdash	Temperature/Cure
	—	Cracks			_	Broken/Damaged	<u> </u>	1	on incomplete		_	art Incorre			Weld
		Crushed/0	Crimped		-	Burrs	Ŀ	1	ions Incomplete/	Unclear		art Lost/Mi	ssing	Ш	Wrong Stock Pulled
	Н	Cuffs				Contamination	<u></u>	Mainte		}-	-	art Moved			
	\vdash	Heat Trea		Tulka	-	Countersink	\vdash	Mislabe		-		Positioned V	-		Other
	$\boldsymbol{\vdash}$	Inspection		iupe	-	Cut Too Short Drill Holes	-	Misread Offset	1	L		ower Loss/	ourge	Ш	Other
		Ripples in Torque W		vtrucia	<u> </u>	Drawing	-	4	Calibration				<u> </u>		
	-	Turning S			"	Finish	-	4	Sequence		_			—	
!	1 1	Lauming 2	Equence]	Trumpit	1	Lour or 3	requerice						

Outside Dimensions

Date:

DQA:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

April-22-13 1:42:43 PM

Page 1

Work Order ID:

100508

Parent Item:

D3910-3

Parent Item Name:

Crosstube Lug

Start Date: 4/18/13

Required Date: 5/03/13

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD

) IPP

IPP REV:B AS PER REV B 10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	628.0000	0.13	5.473684	1/3/0	4/29	
Lug Extrusion				Location		Loc Oty	<u>Lo</u>	c Code				13	·
				MAT006 4372		383 161.5							
	·			8795		221.5							
				Metec 9355		245 245				- (A)			

D3910-37

140

/43/0/s(4)

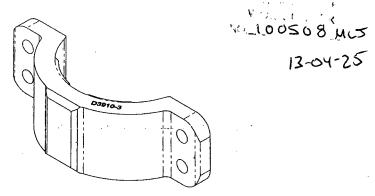
NCR: Ye	es / No	i			WORK ORDER NON-C	CON	FORN	/IANCE / UP	DATE			•		
	- · · · · · · · · · · · · · · · · · · ·	į								QA Closed:	Date:			
Work Order	; .				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS			
Work Order	·· 	:			Rework	1		Skid-tube	Crosstube]	Water Jet	Engineering		
Part No	0.	:			Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
					Use-as-is	1	Therm	oforming	Finishing	Rec/Sto	re/Packaging	Other		
NCR No	0				Work Order Update	1		Large Fab	Composite		Supplier			
Root		[;		Descri	tion of work order update	In	itial	Ac	tion	Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Desc	cription	Date	Verification	QC Inspector		
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Equip/Tooling												ļ		
Operator														
Material														
Setup											ļ			
Other														
Process														
Supplier														
Training	İ													
Unapproved	,													
	i				F.	AULT	CATE	GORY						
Landin	g Gear				General	_			_	•	_	-		
	Bending,			L	Bend	\square	Grain			Ovalized		Pressure/Forced		
	Centre No	ot Concei	ntric to (o/s	BOM/Route	Ш	Hardwa	re		Over/Under	tolerance	Temperature/Cure		
Ĺ	Cracks '				Broken/Damaged		nspecti	on Incomplete		Part Incorre	ct	Weld		
	Crushed/	Crimped		L	Burrs		nstruct	ions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled		
Ĺ	Cuffs				Contamination	\square	Mainte	nance		Part Moved				
	Heat Trea	ıt			Countersink		Mislabe	led		Positioned V		-		
	Inspection	n Strip in	Tube		Cut Too Short		Misread	I		Power Loss/	Surge	Other		
	Ripples in	Bend			Drill Holes		Offset							
	Torque W	aves in E	extrusion	۱ [Drawing		Out of C	Calibration						
	Turning S	equence			Finish		Out of S	equence						
	Wave/Tw	ist in Tub	oe .		Folio		Outside	Outside Dimensions						

DQA: _____Date: _____

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D3910-1

D3910-1 X-TUBE LUG



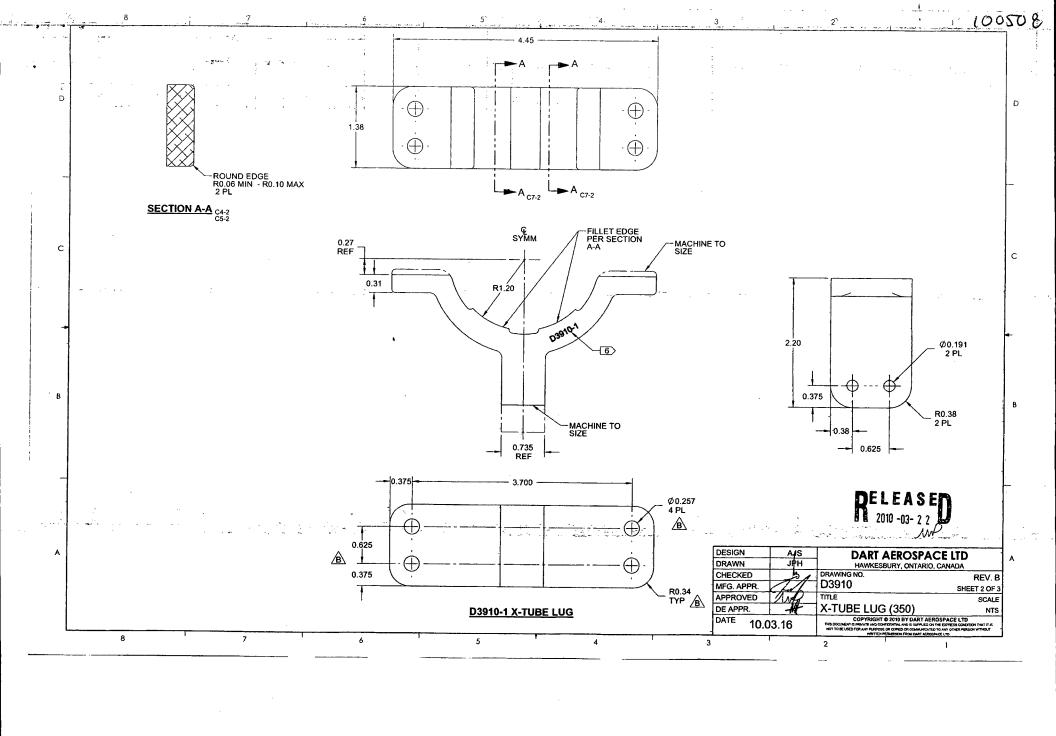
D3910-3 X-TUBE LUG

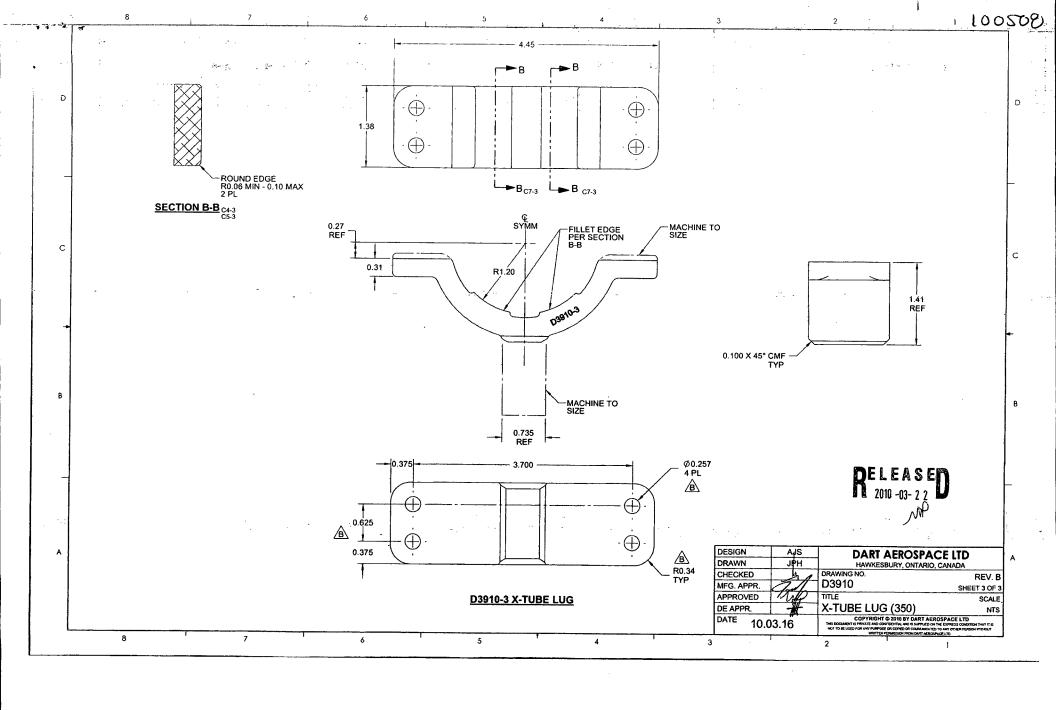
NOTES:
1) MATERIAL: MAKE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS
OF 0.015 ± 0.005
7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

С

8

B	FILLET REASO	WAS RO	0.50 (A3- TR-D350	AS 2 PL (AS-2) & (AS-3); R0.34 2) & (A3-3). -607-2	JPH	10.03.16
Ą	NEW IS				JPH	- 10.03.04
REV.			ι	DESCRIPTION	BY	DATE
DESIGN	١	A	.JS	DART AEROSPA	CEL	TD
DRAWN	١	J	РН	HAWKESBURY, ONTARK		
CHECK	ED		3/	DRAWING NO.		REV. B
MFG. A	PPR.	Z	//	D3910		SHEET 1 OF 3
APPRO	VED	W	1/	TITLE		SCALE
DE APP	R.	4	4	X-TUBE LUG (350)		NTS
DATE	10.0	3.16	j :	COPYRIGHT © 2010 BY DART AI THIS COCUMENT IS PRIVATE AND CONTIDENTIAL AND IS SUPPLIED. NOT TO BE USED FOR ANY PURPOSE OR COPED OR COMMUNICAL	ON THE EXPRES	SS CONDITION THAT IT IS







Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO19722

Purchase Order Date 4/29/13 PO Print Date 4/29/13

Page Number 1 of 1

Order From:

VC-MET003

METEC METAL TECHNOLOGY INC. 20 TERRY FOX DRIVE PO BOX 781 VANKLEEK HILL, ON KOB 1RO

CA

Contact Name

Vendor Phone

613 678 3957

Vendor Fax

613 678 3956

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency **FOB**

Chantal Lavoie

10127-2607 Net 10

CAD

Destination-Collect

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA

Line Nbr Reference

D3910-3P

Revision ID

Description/ Mfg ID

Req Date/

Req Qty/ Taxable Unit of Measure

Ship Method

Unit Price

Extended

Price

Vendor Part Number

Crosstube Lug

5/06/13 Yes 40.00 Dart Truck Each

\$31.5500

\$1,262.00

Special Inst:

AS PER DWG D3910 REV. B

B100508

PO Total:

\$1,262.00





No substitution or deviation without consent.

Certificate of Conformity or Material NO Certification required - KES

Change Nbr:

Change Date:

4/29/13



20 Terry Fox Drive Vankleek Hill, Ontario K0B 1R0 , Canada Tel: (613) 678-3957

Fax: (613) 678-3956

Delivery Slip No.:

19027

Date:

May 07, 2013

Page:

Thank you for your order!

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No: PO19722	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date: May 07, 2013

	Description.		Unit.	Ordered quantity	Shipped quantity =	Backorder quantity
3910-3 (rosstube Lug as per dwg. D3910 Rev.B		Each	40	40	
	·					
				1		
Should ther	ed goods must be inspected upon receipt to confirm be discrepancies please notify METEC within 30 date otherwise deemed accepted.	compliance. ays of delivery.				



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

SHIPPED TO:

Dart Aerospace Ltd. 1270 Aberdeen Street

Hawkesbury, Ont.

K6A 1K7

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

40

D3910-3

Cross tube

PO 19722

MATERIAL: supplied by DART

B93551

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, May 7, 2013